

Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2017-179 Date Opened: 03 November 2017 Title: Fabrication

Aircraft OEM: Multiple Aircraft Model: Multiple Product Type: Cargo Basket Lid Product Model: Medium Quantity: 10

Work Order Contents

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

JL
N/A
JL
JL
N/A
JL
N/A
N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

10
0
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JL
JL

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Tracking (White) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
JL
N/A
N/A
JL

Drawing List

Drawing #	Rev #	Description	Initial or N/A
69812	4	Lid	JL
70405	4	Lid Walkway	JL

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JL
N/A
N/A

Traveller

Initial or N/A

Work performed by:

ICC / Dual Inspection performed by:

Work Order closed by:

Print: J. FRANCIS / J. REKVE

Print: J. CLARKE

Print: J. CLARKE

Sign: [Signature]

Sign: [Signature]

Sign: [Signature]

SCA: AD01

SCA: AD02

SCA: AD02

Date: 09 FEB 2018

Date: 09 FEB 2018

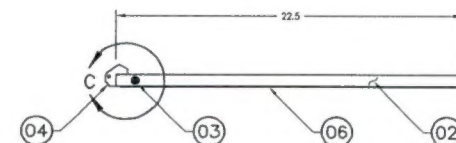
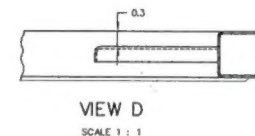
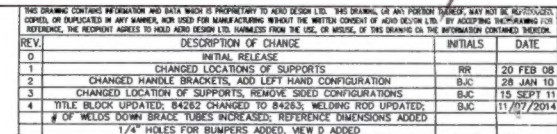
Date: 14 MAR 2018

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

X (10) with walk way




RIGHT HAND ASSEMBLY SHOWN. LEFT HAND OPPOSITE

NOTES

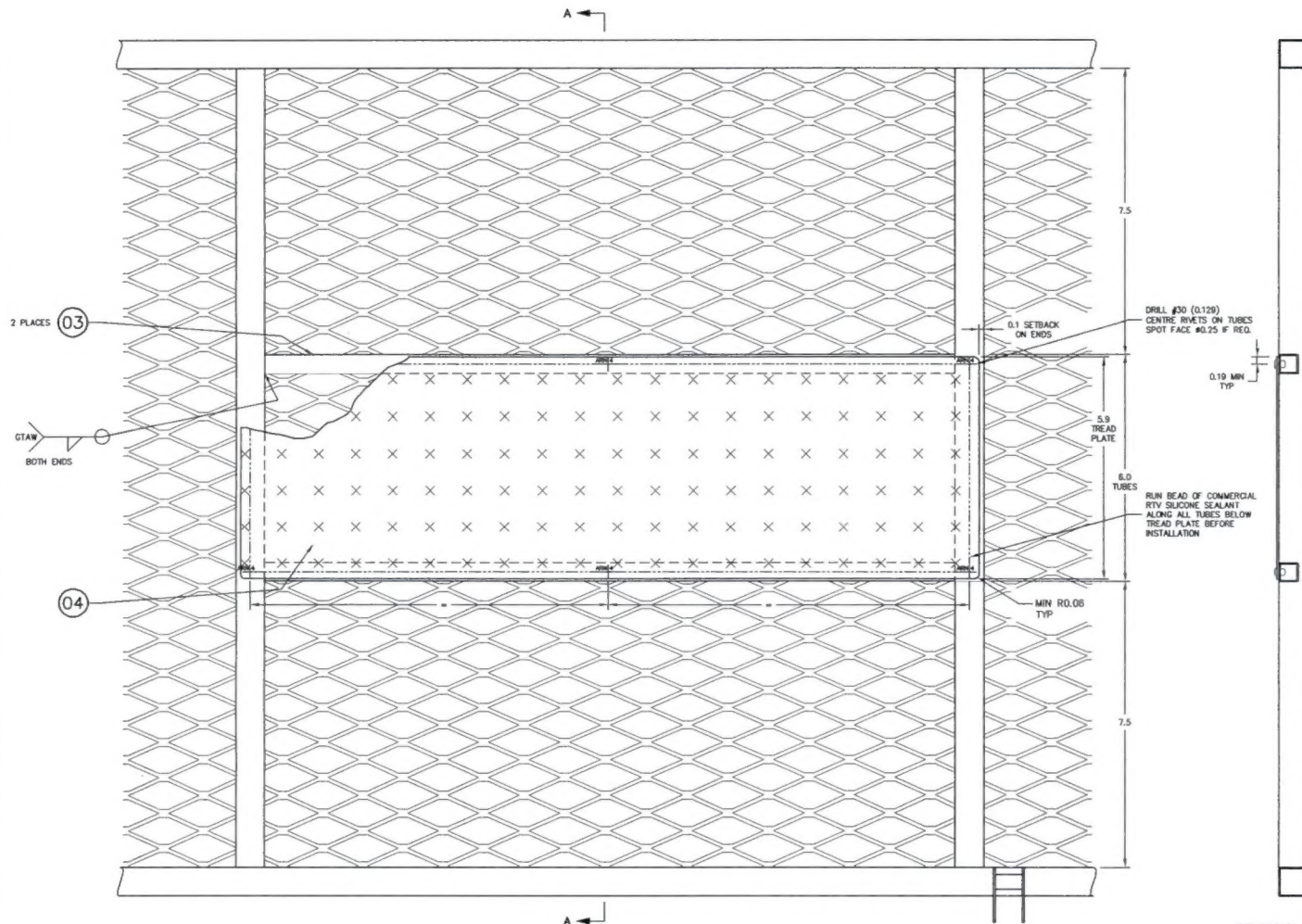
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C.
4130 AND 1018 STEEL WELDING ROD SHALL CONFORM TO E70TS-2 OR EQUIVALENT.
STAINLESS AND 4130 STEEL WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
3. INSTALL ITEM 4 (4 HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. 54653.
4. **⚠** INSTALL #10 (1/12) HOLES IN LONG TUBE MEMBERS AT BRACE LOCATIONS TO VENT WELD GASSES.
WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
5. FINISH THOROUGHLY CLEAN AND POWDER COAT LD ASSEMBLY.



DETAIL A
LOOKING AT TOP

A/R	3/4-16F	06	MESH	MILD STEEL	COMMERCIAL							
1	36204-10	05	PLACARD BRACKET									
1	84263-01	04	LID HANDLE PROVISIONS ASSEMBLY									
2	49216-01	03	SPACER									
A/R	--	02	TUBE	4130 STEEL, COND. N	MIL.-T-8736	0.75 X 0.035 SQR. TUBE						
	68612-01	01	BASKET LID ASSEMBLY									
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE						
QTY	LIST OF MATERIALS											
<table><tr><td>APPROVALS</td><td>DATE</td></tr><tr><td>DRAWN: JEFF CLARKE</td><td>11 APR 2006</td></tr><tr><td>CHECKED: E. BURGIN</td><td></td></tr></table>				APPROVALS	DATE	DRAWN: JEFF CLARKE	11 APR 2006	CHECKED: E. BURGIN		<div>AERO DESIGN LTD. 6868A MALAYSIA ROAD POWELL RIVER, BC, CANADA V8A 0G3 TEL: 604-683.2376 www.aerodesign.ca</div>		
APPROVALS	DATE											
DRAWN: JEFF CLARKE	11 APR 2006											
CHECKED: E. BURGIN												
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ±0.010 ANGLES ±1/2° X.XXX ±0.010 X.XX ±0.03 X.X ±0.1				QUICK RELEASE CARGO BASKET BASKET LID ASSEMBLY								
SCALE 1 : 4 SHEET 1 OF 1				A1	69812	4						

2017-179 X (10)



(01) BASKET LID ASSEMBLY

SECTION A-A

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135, MOOREHEAD DOUGLAS W6060H, BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALT. RIVET; ADD NOTE 7	BJC	29/05/2014

NOTES:

1. THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
2. TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
3. REMOVE ALL BURRS AND BREAK SHARP EDGES.
4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
7. WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R	CR3213-4-02	BLIND RIVET	ALTERNATE: HR3213-4-02			
1	70405-04	TREAD PLATE	ALUMINUM	COMMERCIAL	0.063 TREAD PLATE	
2	70405-03	03 TUBE	4130 STEEL COND. N	MIL-T-8736	0.5 X 0.035 WALL TUBE	
1	SEE NOTE 1	02 BASKET LID ASSEMBLY				
1	70405-01	01 BASKET LID ASSEMBLY - MODIFIED WITH STEP				
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
				LIST OF MATERIALS		

BASIC CODE REF. NAS 523 C=COUNTERSUNK D=DIMPLE DIGIT=# OF SHEETS TO BE DIMPLED		DASH NO. FOR DIAMETER H=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE DASH NO. FOR LENGTH		APPROVALS DRAWN: JEFF CLARKE 21 SEPT 2008 CHECKED: E. BURGOIN		DATE 21 SEPT 2008	
BASIC CODES: BU=MS20470AD BB=MS20426AD ARN=CR3213 ARN=CR3212				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ±0.010 .XXX ±0.03 .XX ±0.1 ANGLES ±1/2°			
+ INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET				LIST OF MATERIALS AERO DESIGN LTD. 8806A MALASPINA ROAD POWELL RIVER, BC, CANADA V0A 0G3 TEL: 804.483.2878 www.aerodesign.ca			
SCALE 1 : 1.5 SHEET 1 OF 1				DWG. SIZE A1			
DWG. NO. 70405				REV. 4			

2017-179
X(10)

CARGO BASKET LID FABRICATION - COMMON

General

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket

94612, Revision 0 – Extra-Wide Low Mounted Ski Basket

76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77612, Revision 1 – Short Basket

69812, Revision 3 – Medium Basket (left and right) ← *

78412, Revision 2 – Long Basket

94012, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90612, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80212, Revision 0 – Short Basket

80312, Revision 0 – Medium Basket

81112, Revision 0 – Long Basket

Bell 429 – right or left

95912, Revision 0 – Standard Basket

Bell Medium – left or right

75112, Revision 0 – Standard Basket

95512, Revision 0 – Extra Large (ski) Basket

MD600

82812, Revision 0 – Standard Basket

Options

70405, Revision 3 – Walkway

70402, Revision 1 – Lid Door

1-5

CARGO BASKET LID FABRICATION

Work Order: 2017-179Date Open: 03 NOV. 2017Complete
(initial or SCA #)X (10)
with walk way

1. Rim Assembly – Basket Lid

- Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig, 45 degree ends.
 - 1 or 2 lid prop bushing holes in short tube – refer to drawing
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright

2. Weld Rim Assembly

- Record welding rod PO on attached material list.

3. Inspection

- Rim for complete welds

4. Frame assembly – Lid

- General
 - Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
- Insert rim from step 2 into jig.
- Cut and fit $\frac{3}{4}$ " x 0.035 material, 21" long, for lid cross members.
- Record material PO on attached material list.
- Remove writing on tubes with acetone and scotch bright.
- Drill vent holes into rim to vent cross members into rim.
- Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

5. Frame assembly – Lid with optional walkway modification

- Fit cross members to rim in accordance with step 4.
- Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
- Cut $\frac{1}{2}$ " x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
- Drill vent holes into cross members at walkway stringers.
- Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

6. Weld frame assembly.

- Record welding rod PO on attached material list.
- Jigs must remain in place for as long as practical during welding.

7. Inspection

- Frame assembly for complete welds.

AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
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AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
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AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
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AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
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AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
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AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
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AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
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CARGO BASKET LID FABRICATION

Complete

(initial or SCA #)

8. Mesh assembly.

Note: 95912 (Bell 429) does not have mesh. Skip to step 10.

- Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- Cut mesh to size for lid.
- Remove surface rust with scotch-brite.
- Ensure lid is prepared for mesh on the correct side.

9. Weld mesh to frame assembly per drawing.

- General welding requirements for all lids:
 - Every intersection on all edges.
 - First 5 intersections along cross members, then every second intersection.
- MIG weld both short sides.
- Clamp lid over spacer at centre of lid to pre-tension mesh.
 - $\frac{3}{4}$ " for lids under 76"
 - 1" (check) for lids over 76"
- Weld remainder of mesh as indicated in a.
- Record welding rod PO on attached material list.

10. Weld lid components.

- Handle brackets, locate in accordance with drawing.
 - Standard location: $\frac{1}{4}$ " outside of last cross member on both ends.
 - Record handle bracket WO and welding rod PO on attached material list.
- Lid prop bushing(s).
 - one or two in accordance with drawing.
 - Record lip prop bushing WO and welding rod PO on attached material list.
- Placard bracket. – not installed on 95912 (Bell 429)
 - Locate on cross member to set bracket in centre bay of lid.
 - Record placard bracket WO and welding rod PO on attached material list.

11. Clean up

- Grind high spots off mesh welds.
- Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
- Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
- Drill #9 through lid prop bushing(s). De-burr hole(s).
- ~~Drill for lid bumpers using $\frac{1}{4}$ " (#3) centre drill.~~
 - ~~3 places for lids under 76"~~
 - ~~4 places for lids over 76"~~
- Remove surface rust with scotch-brite pad.

12. Final Inspection

To be completed by a different person than the previous steps.

- Basket lid assembly for complete welds, and required minimum mesh weld locations.
- Material lists complete.
- Overall condition and conformity to drawing(s).

CARGO BASKET LID FABRICATION

13. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag lid assembly and place into stock in preparation for assembly.

AD
73-04
02

AD
73-04
02

AD
73-04
02

Complete
(initial or SCA #)

AD
73-04
02

AD
73-04
02

CARGO BASKET LID FABRICATION - COMMON**General**

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket

94612, Revision 0 – Extra-Wide Low Mounted Ski Basket

76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77612, Revision 1 – Short Basket

69812, Revision 3 – Medium Basket (left and right)

78412, Revision 2 – Long Basket

94012, Revision 0 – Extra Large (ski) Basket

**Robinson R44 – left or right**

90612, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80212, Revision 0 – Short Basket

80312, Revision 0 – Medium Basket

81112, Revision 0 – Long Basket

Bell 429 – right or left

95912, Revision 0 – Standard Basket

Bell Medium – left or right

75112, Revision 0 – Standard Basket

95512, Revision 0 – Extra Large (ski) Basket

MD600

82812, Revision 0 – Standard Basket

Options

70405, Revision 3 – Walkway

70402, Revision 1 – Lid Door

6-10

CARGO BASKET LID FABRICATION**Complete**
(initial or SCA #)Work Order: 2017-179Date Open: 03 NOV. 2017

1. Rim Assembly – Basket Lid

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig, 45 degree ends.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.

2. Weld Rim Assembly

- a. Record welding rod PO on attached material list.

3. Inspection

- a. Rim for complete welds

4. Frame assembly – Lid

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
- b. Insert rim from step 2 into jig.
- c. Cut and fit $\frac{3}{4}$ " x 0.035 material, 21" long, for lid cross members.
- d. Record material PO on attached material list.
- e. Remove writing on tubes with acetone and scotch bright.
- f. Drill vent holes into rim to vent cross members into rim.
- g. Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

5. Frame assembly – Lid with optional walkway modification

- a. Fit cross members to rim in accordance with step 4.
- b. Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
- c. Cut $\frac{1}{2}$ " x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
- d. Drill vent holes into cross members at walkway stringers.
- e. Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

6. Weld frame assembly.

- a. Record welding rod PO on attached material list.
- b. Jigs must remain in place for as long as practical during welding.

7. Inspection

- a. Frame assembly for complete welds.

AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05
AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05	AD 73-04 05

2017-179

CARGO BASKET LID FABRICATION**Complete**

(initial or SCA #)

8. Mesh assembly.

Note: 95912 (Bell 429) does not have mesh. Skip to step 10.

- Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- Cut mesh to size for lid.
- Remove surface rust with scotch-brite.
- Ensure lid is prepared for mesh on the correct side.

AD AD AD AD AD
73-04 73-04 73-04 73-04 73-04
05 05 05 05 05

9. Weld mesh to frame assembly per drawing.

- General welding requirements for all lids:
 - Every intersection on all edges.
 - First 5 intersections along cross members, then every second intersection.
- MIG weld both short sides.
- Clamp lid over spacer at centre of lid to pre-tension mesh.
 - $\frac{3}{4}$ " for lids under 76"
 - 1" (check) for lids over 76"
- Weld remainder of mesh as indicated in a.
- Record welding rod PO on attached material list.

AD AD AD AD AD
73-04 73-04 73-04 73-04 73-04
05 05 05 05 05

10. Weld lid components.

- Handle brackets, locate in accordance with drawing.
 - Standard location: $\frac{1}{4}$ " outside of last cross member on both ends.
 - Record handle bracket WO and welding rod PO on attached material list.
- Lid prop bushing(s).
 - one or two in accordance with drawing.
 - Record lip prop bushing WO and welding rod PO on attached material list.
- Placard bracket. – not installed on 95912 (Bell 429)
 - Locate on cross member to set bracket in centre bay of lid.
 - Record placard bracket WO and welding rod PO on attached material list.

11. Clean up

- Grind high spots off mesh welds.
- Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
- Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
- Drill #9 through lid prop bushing(s). De-burr hole(s).
- ~~Drill for lid bumpers using $\frac{1}{4}$ " (#3) centre drill.~~
 - ~~3 places for lids under 76"~~
 - ~~4 places for lids over 76"~~
- Remove surface rust with scotch-brite pad.

AD AD AD AD AD
73-04 73-04 73-04 73-04 73-04
05 05 05 05 05

12. Final Inspection

To be completed by a different person than the previous steps.

- Basket lid assembly for complete welds, and required minimum mesh weld locations.
- Material lists complete.
- Overall condition and conformity to drawing(s).

AD AD AD AD AD
73-04 73-04 73-04 73-04 73-04
02 02 02 02 02

CARGO BASKET LID FABRICATION

13. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag lid assembly and place into stock in preparation for assembly.

AD	AD	AD	Complete
73-04	73-04	73-04	(initial or SCA #)
02	02	02	
AD	AD		
73-04	73-04		
02	02		

Work Order: 2017-179Date Opened: Nov 2017

Material Tracking Sheet
Bell 206L / 407 and Eurocopter AS350 / AS355
Lid Fabrication

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>10</u>		69812-01	Lid Assembly		
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (75.75")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>17091</u>
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>17055/17091/207-153</u>
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>16078</u>
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 3		--	3/4" Tube - Cross Member (21")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>17004/15072/14099</u>
Step 5		70405		<i>Option: Frame Assembly - with walkway</i>		
	. 8		--	1/2" Tube - walkway	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>17038/17082</u>
Step 6				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>16078</u>
Step 7				<i>Inspection - Frame Assembly</i>	None	
Step 8				<i>Mesh Assembly</i>		
	. 1		--	Mesh (lid - 75" x 22")	3/4-16F Expanded Mild Steel sheet	<u>17025</u>
Step 9				<i>Weld Mesh</i>		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	<u>16078</u>

Work Order: 2017-179Date Opened: Nov 2017

Material Tracking Sheet
Bell 206L / 407 and Eurocopter AS350 / AS355
Lid Fabrication

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 10				<i>Weld Lid Components</i>		
Step 10.a.	1	84262	84262-01	Upper Handle Bracket Assembly		2016-147
	4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	
	2		36275-02	Support	304 Stainless, 5/16" Rod	
	A/R		--	Welding Rod	ER308L TIG Rod	17066
Step 10.b.	2		49216-01	Spacer (Lid prop)	304 Stainless, 1/2" Dia.	2015-84
	A/R		--	Welding Rod	ER308L TIG Rod	17066
Step 10.c.	1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	2016-119
	A/R		--	Welding Rod	ER70S-2 TIG Rod	16078
Step 11				<i>Clean Up</i>		
Step 12				<i>Inspection - Final Assembly</i>		
Step 13				<i>Powder Coating</i>	17110 17117 17118 18009 (2) (2) (2) (4)	